

3500



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101896-7
Job Sheet 179936



SHIP 713

Part No: RB T101896-7

Job Qty: 2 ea

Part Name: Side Bar



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/26/18

Job Tracking No:

Due Date: 6/25/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T101896 Rev. A IPP Rev. A 18.05.24 new issue DP Verify DD

Ship Via:

NO PAW

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	2 Ea		6/25/18	0.00	0.00	Start Up Machining-2		
110	Mill Conv	2 pcs		6/25/18	0.00	2.00	Mill Conv 2		
120	QC	2 pcs		6/25/18	0.00	0.00	QC2 Machining-4		
125	QC	2 pcs		6/25/18	0.00	0.00	QC8 Machining-2		
130	Packaging	2 pcs		6/25/18	0.00	0.00	Packaging3-2		
140	QC21-SA	2 Ea		6/25/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. DWG REV: _____ 2-Deburr

DAS
21
9-30

JUL 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.000X1.000	4140 Steel Bar 1.000 X 1.000	4.3800 ft (2.19 ea)	100-Start up Operation	5090107

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	MT-4140-B-1.000X1.000 98530A989	4	40	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 7/5/18 10:21 AM dart.logan.david

Container No: S090219



Part: RB T101896-7

Job No: 179936

Serial No/Batch: S090219

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 07/09/18

LARGE FAB

3050



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101896-7

Job Sheet 178330



SHIP

7-13

No
FAIL

Part No: RB T101896-7

Job Qty: 12 ea

Part Name: Side Bar



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 6/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T101896 Rev. A IPP Rev. A 18.05.24 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	12 Ea	6/4/18	6/4/18	0.00	0.00	Start Up Large Fab-7		
110	Mill Conv	12 pcs	6/4/18	6/4/18	0.00	12.00	Large Fab 1		
120	QC	12 pcs	6/4/18	6/4/18	0.00	0.00	QC9		
130	Packaging	12 pcs	6/4/18	6/4/18	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea	6/4/18	6/4/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG DWG REV: _____ 2-Deburr
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.000X1.000	4140 Steel Bar 1.000 X 1.000	26.2800 ft (2.19 ea)	100-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	MT-4140-B-1.000X1.000	26	40	0

Part Specifications

Specifications could not be found.

x 6/22/18 10:20 AM dart.logan.david

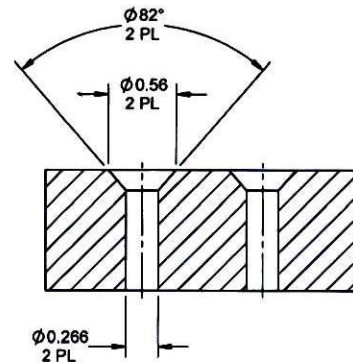
Hello Dan,
This needs a
Revised Routing
as per Guillaume
David 6-26 10:40 AM

→ then → welded assy is a (-3)
-9 and -7 should be on (Mill Conv)

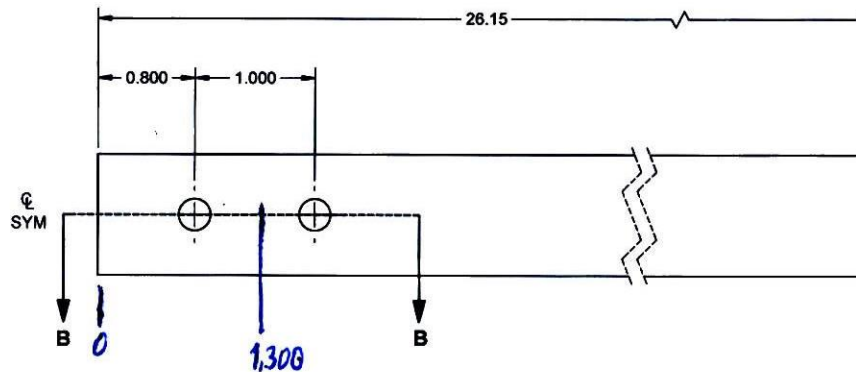
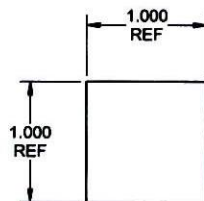
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178330

20180622

Handwritten mark



SECTION B-B



RB T101896-7 SIDE BAR

NOTES:

- 1) MATERIAL: McMaster# 98830A989 OR EQUIVALENT
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES:

X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

RELEASED

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101896	SHEET 4 OF 9
APPROVED	<i>Mee</i>	TITLE	SCALE
DATE	5/28/2018	M/R GRIP SPACING TOOL	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

179936
~~178320~~

Page 1 of 1

Inspection	
Denver CLK-19	
"	
A-1000	
Denver CLK-19	
"	
"	
"	
"	

18/7/9

Date:

Revised by	Approved
KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Q Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								